

Work Order ID 146814

Tuesday, May 24, 2016 9:54:54 AM

146814

Page 1

Item ID: D5311-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Prop Rod

Start Date: 6/1/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/1/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5311

B

110

0.00

110

Small Fab

Small Fab

Memo

0.00

1- CUT AT 12.00"

2- PUNCH ONE END AS SPEC CONTROL DWG (SEE NOTE8)

3- TRIM OFF ACCESS MATERIAL AS PER DWG.

4- DRILL HOLE AS PER DWG AND DEBURR

3

FF

JUN 09 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

3

DAS
38

JUN 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐
Material ☐	☐	Use for Testing ☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	☐	Past Due ☐					

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Page 2

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Accept

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Cust Item ID:

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3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: W/A01

0.00

130

Packaging

Memo

0.00

Packaging

3 EL 16-6-13

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS JUN 14 2016MCS JUN 14 2016

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER : _____									

Picklist Print

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Work Order ID: 146814

146814

Parent Item: D5311-7

D5311-7

Parent Item Name: Prop Rod

Start Date: 6/1/2016

Required Date: 6/1/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IIN REV:A 16.02.10 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

f

242.1576

3.157895

M304TR0 750W 049

FF JUN 09 2016

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

GA002

236.5848232

M132270

0.00001

M133131

0.0007242

M133509

14.210211

M133700

8.85327

M133914

5.98516

M134138

1.1364496

M134212

9.8302125

M134306

41.2895779

M134528

62.890263

M134604

52.388945

M134824

40

MAT

5.5727347

M133400

5.5727347

3.157895

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process								
Misidentified ☐	☐	Past Due								

INSPECTION SHEET

DAS

30
9-89

Date:

Revised by
KJ